Dart Aerospace Ltd. Tuesday, 7/11/2006 1:05:18 PM Kim Johnston User: **Process Sheet Drawing Name** : SPACER : CU-DAR001 Dart Helicopters Services Customer Job Number : 27864 : 10383 **Estimate Number** :WLA **Part Number** : D30661 P.O. Number . D3066 REV.B : 7/11/2006 **Drawing Number** This Issue : N/A : NC **Project Number** Prsht Rev. : NA : SMALL /MED FAB Type **Drawing Revision** First Issue :NIA : 27666 Material **Previous Run Due Date** : 7/18/2006 Qty: 40 Um: Written By Checked & Approved By Incorporated D3066-1 IPP KJ/RF Comment : Est:C Now M6061-T6 06-06-23 JLM Est Rev:B **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: M6061T6S080 6061-T6 .080 Sheet 1.0 Comment: Qty.: Total: 3.9690 sf(s)0.0992 sf(s)/Unit Material: 6061-T6 0.080" thick (M6061T6S.080) Batch: MIOU78 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3066 Dwg Rev:_/_ 06/07/17. Prog Rev:_\(\mathcal{B}\) 2-Deburr if necessary 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Comment: SECOND CHECK

5.0 HAND FINISHING1

QC8

HAND FINISHING RESOURCE #1

SECOND CHECK

Comment: HAND FINISHING RESOURCE #1

HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1





4.0

90

Each

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANGE	3			
DATE	STEP	PROCEDURE CHANGE			Ву	Date Q	Approval Mfg / Design Mgr	Approval QC Inspector
Non			WORK ORDE	R NON-CONFORMAN	ICE (NCR			
NCR:	T			Corrective Action Section B		/		<u></u>
DATE	STEP	Description of NC Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
Part No	o:	PAR #:	Fault Category	:NCR:	Yes No I	DQA:	Date: <u>△</u>	6/07b5
NOTE: D	ate & initia	al all entries			QA: N/C Cld	sed:	Date: _	

H:\forms\Quality Assurance\approved forms\NCRWO revC

Tuesday, 7/11/2006 1:05:19 PM Date: Kim Johnston User: **Process Sheet Drawing Name: SPACER** Customer: CU-DAR001 Dart Helicopters Services Part Number: D30661 Job Number: 27864 Job Number: Description: Seq. #: Machine Or Operation: INSPECT POWDER COAT/CHEMICAL CONVERSION 6.0 OC3 Comment: INSPECT CHEMICAL CONVERSION COAT PACKAGING RESOURCE # 7.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: DC DOCUMENT CONTROL 8.0 Comment: DOCUMENT CONTROL Inspection Level 21 U 807-17 Job Completion

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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector				
			,								

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
DATE		Description of NC	T	Corrective Action Section B	Verification	A	Approval				
	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector			
			•								
		·									

Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	Date:	
NOTE: Date & initial all entries				QA: N	1/C C	losed:	Date:	

DART AEROSPACE LTD	Work Order:	27864
Description: Spacer	Part Number:	D3066-1
Inspection Dwg: D3066 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype	9
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005 -0.000	0.128	V,		VERY	
0.708	+/-0.010	0.716	J		VEEN	
0.35 & 4	+/0.010	0.349	V		VERN	
0.35	+/0.010	0.350	J		VRVN	
2.250 (Pitch)	+/-0.005	2.252	✓		VerN	
16.450	+/0.010	2.252	/		Very Mensurin	a tape
			·			

	1 _ 1				
Measured by:	MI MI	Audited by:		Prototype Approval:	N/A
Date:	06 07 17	Date:	Q:07.17	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.09.22	New Issue P/O D3065-041	KJ/RF	-1
В	06.06.23	Dwg Rev. changed	KJ/JLM 🚓	

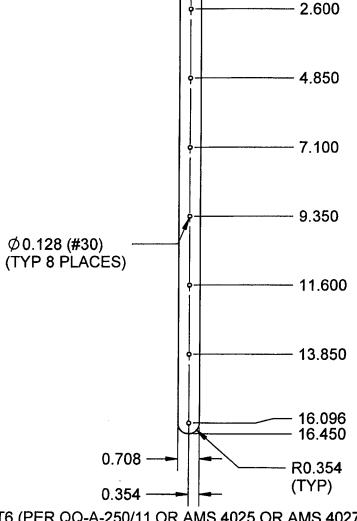


DESIGN DRAWN BY DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA APPROVED, DRAWING NO. REV. B CHECKED D3066 SHEET 1 OF 1 DATE TITLE SCALE 06.05.29 **SPACER** 1:3 Α 02.09.11 **NEW ISSUE** В 06.05.29 ADD 6061-T6 MATERIAL

0.000

0.354

RELEASED de de za



1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK COPY (REF DART SPEC M6061T6S.080) RETURN TO

ENGINEERING

5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICKUNCONTROLLED COPY (REF DART SPEC. M5052H32S.080) SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK OF DER

2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) PART IS SYMMETRIC ABOUT CENTERLINE 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

D3066-1 SPACER

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